

Date: Thursday, 11/15/2007 1:27:19 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 35783	
Estimate Number : 12487	
P.O. Number :	Part Number : D35021
This Issue : 11/15/2007 S.O. No. :	Drawing Number : D3502 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 32205	Material :
Written By :	Due Date : 12/20/2007 Qty: <del>40</del> <sup>20</sup> Um: Each
Checked & Approved By : <u>8/07/11/16</u>	
Comment : Est Rev:A New Issue 06-07-06 JLM	
Est Rev:B Add tooling hole 07-03-28	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X04000 6061-T6 Bar 1.0" x 4.0"



Comment: Qty.: 0.3035 f(s)/Unit Total : 12.1380 f(s)  
 6061-T6 Bar 1.0" x 4.0"  
 batch: M106348

J.L 08/03/10

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blank 3.475" long

J.L 08/03/10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B

PTO →

2-Deburr per dwg D3502

DIP 08/03/12

SF 08/03/12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/03/12

5.0 QC8 SECOND CHECK




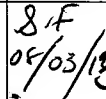
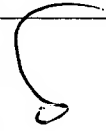


Comment: SECOND CHECK

SA 08/05/14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: N/A Fault Category: Prod / Machined parts NCR: Yes No DQA: Yes Date: 08/03/19  
 QA: N/C Closed: Yes Date: 08/03/19

NCR: <u>35783</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/12	3.0	First parts was scrap because the operator who made the setup put the jig on the wrong side. R.C operator error.	 08.03.14	Scrap as Defect Replace <u>Qty x1</u> B-M <u>106348</u>	 08/03/13	 08/03/13	 08.03.14	 08/03/13

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 35783

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Drill as per Dwg D3502.

*Bo 08/03/14 (40)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*M-L 08/03/17 (40X)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*MA 107005 BR 08-03-18 (40)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M-L 08/03/18 (40X)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*105 8/3/18 SLD (40)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*LD 08/03/19 (40)*

Job Completion



*mi 2008/3/18 (40)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

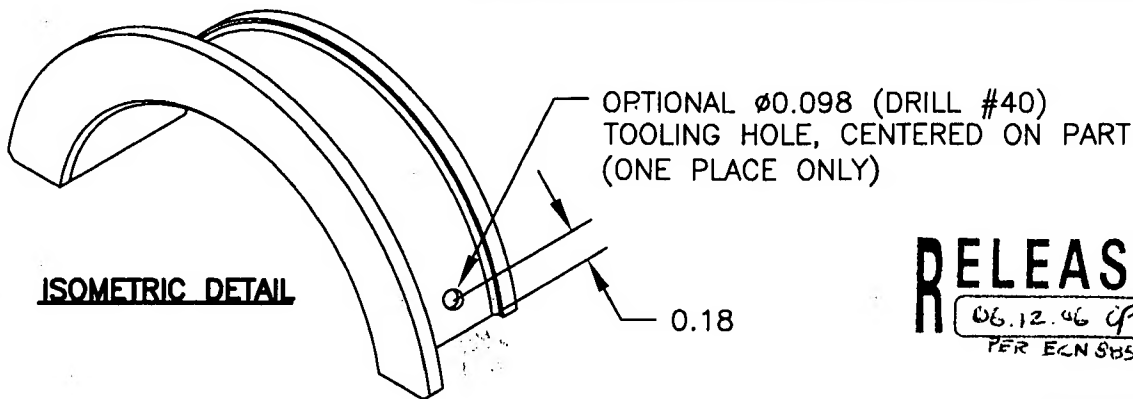
**NOTE:** Date & initial all entries



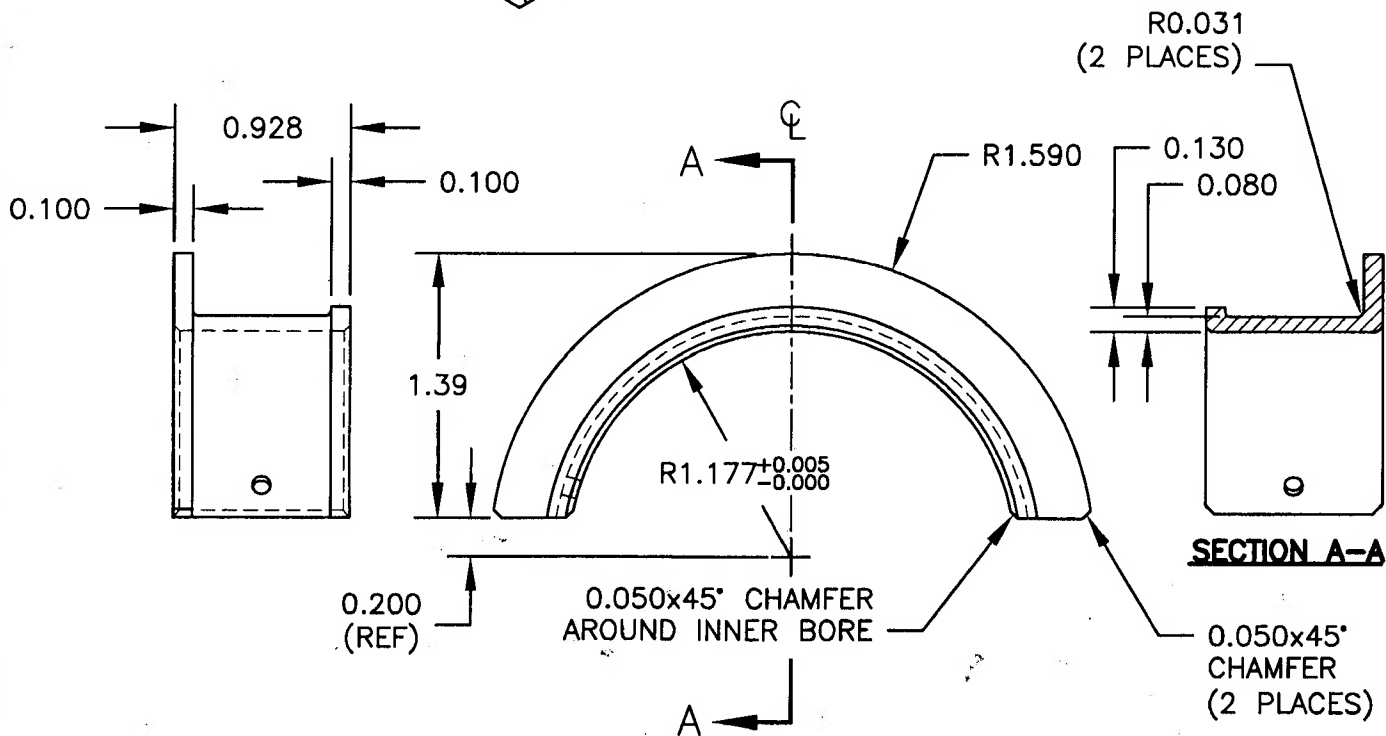


**DART**

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



**RELEASED**  
06.12.06 qp  
PER ECN 835



### D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY  
RETURN TO  
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UNLESS  
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WITHOUT NOTICE  
WORK ORDER  
NO. 35783

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